

Work Order ID# 65989

Tuesday, February 01, 2011 7:12:35 AM

Page 1

Item ID: D3389-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 2/1/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: 

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3389

Rev D

100

0.00



Skidtubes

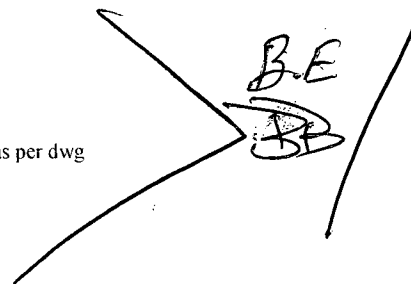
Skidtubes

Memo

0.00

Skidtubes

- 1- Pick D2500-3-100
- 2- Deburr
- 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.
- 4- Cut to finished length
- 5- Open holes to finished size as per dwg D3389
- 6- Deburr



11-2-18

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

DP

11-2-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65989

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Page 2

Item ID: D3389-1

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Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 2/1/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BB

11/02/01

8

Memo

0.00

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

DP

11-2-1

8

Memo

0.00

140



Packaging

Packaging

Identify as per dwg & Stock Location:

46

0.00

DP

11-2-1

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 2/1/2011 Start Qty: 8.00

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/02/02
CMF
11-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 01, 2011 7:12:32 AM

Page 1

Work Order ID: 65989

Parent Item: D3389-1

Parent Item Name: Web



Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 105.08.31 New issue TKJ/JLM
 IPP Rev:B 06-02-08 As per Rev C JLM
 IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

56.0000

1

8



Ext'n - I Beam Web 4"



BE 1/02/01

Location

Loc Qty

Loc Code

LG

56

51957

56

8

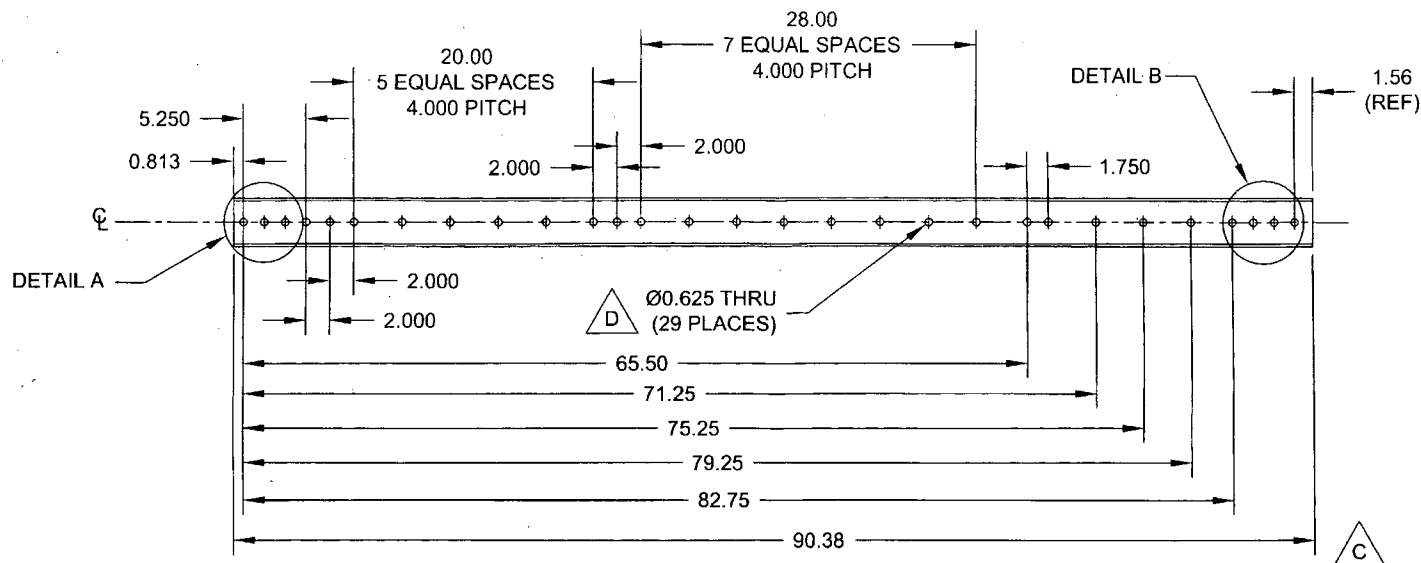
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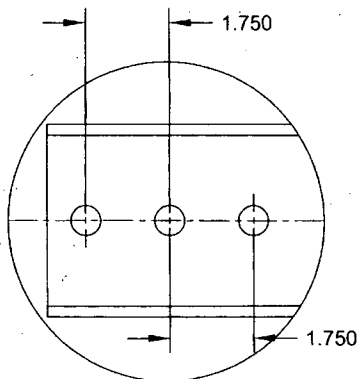
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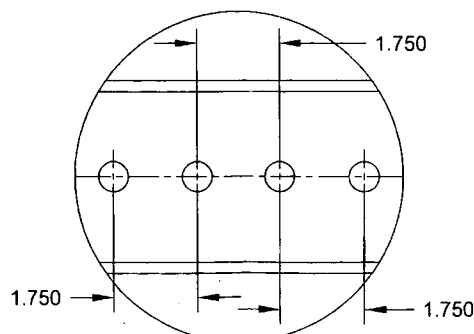
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3389 TITLE 412 WEB SCALE 1:10	
DATE	07.10.09	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/065989